

Date: Friday, 14/11/2008 7:31:41 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DRAIN TUBE ASSEMBLY
<b>Job Number</b> :	43438	<b>Part Number</b> :	D2127251913
<b>Estimate Number</b> :	12622	<b>Drawing Number</b> :	D212-725-1 PG28
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	14/11/2008	<b>Drawing Revision</b> :	B
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	/ /	<b>Due Date</b> :	21/11/2008
<b>Previous Run</b> :	42608	<b>Qty:</b>	2
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A New Issue 07-01-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W



**Comment:** Qty.: 3.4650 f(s)/Unit Total: ~~3.4650~~ f(s)  
304SS TUBE .75" X .049" WALL *6.93*  
Batch: *17 109314*

*FF 08/11/19* (2)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Form tube as per Dwg D212-725-1 & DT8908 Template

*FF 08/11/19* (2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

*\*no knots or dents found.\**

*Sosluh* (2)

4.0	AN81812J	Nut
-----	----------	-----



**Comment:** Qty.: 2.0000 Each(s)/Unit Total: ~~2.0000~~ Each(s)  
Nut *4.0000*  
Batch: *m 1238*

*FF 08/11/19* 2

5.0	MS2081912J	Sleeve
-----	------------	--------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total: ~~2.0000~~ Each(s)  
Sleeve *4.0000*  
Batch: *m 819*

*FF 08/11/19* 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 14/11/2008 7:31:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRAIN TUBE ASSEMBLY

Job Number: 43438

Part Number: D2127251913

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install sleeves & nut then flare tube as per Dwg D212-725-1.

FF 08/11/19

(2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/11/20 (42)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 120

8/11/20

(2x)

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/20

Job Completion



MF 08-11-20

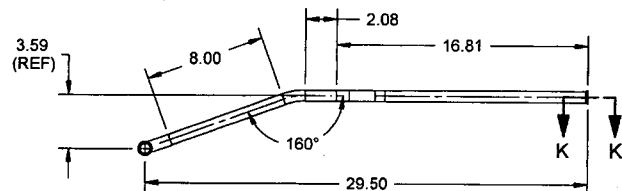
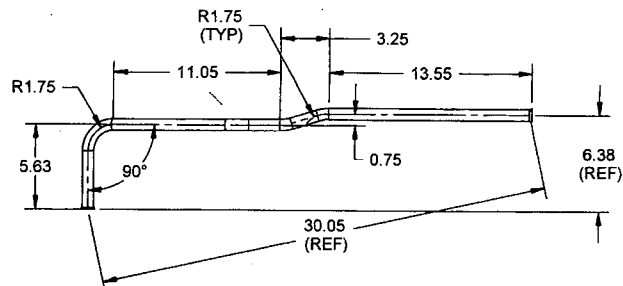
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

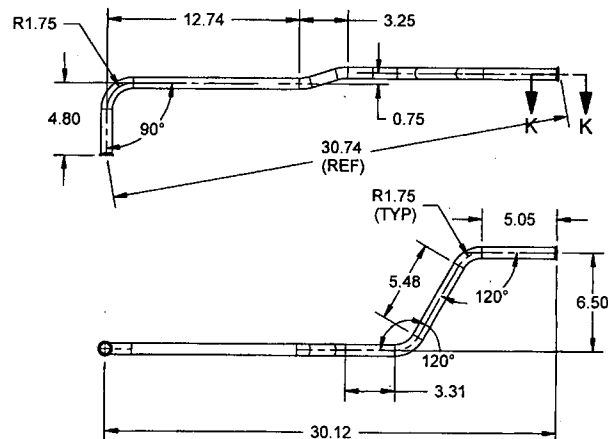
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



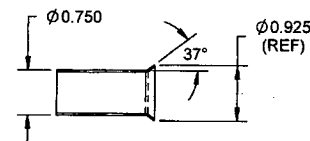
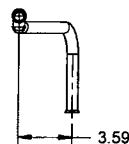
**D212-725-1-071 DRAIN TUBING**  
MANUFACTURE PER TEMPLATE DT8908



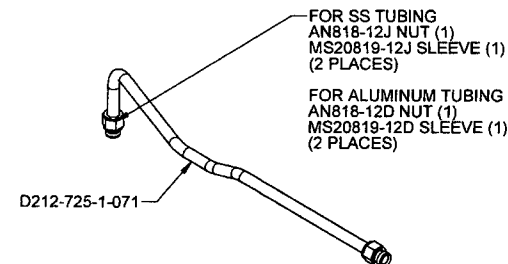
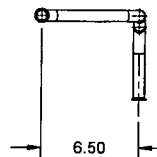
**D212-725-1-073 DRAIN TUBING**  
MANUFACTURE PER TEMPLATE DT 8909

**D212-725-1-071/-073:**

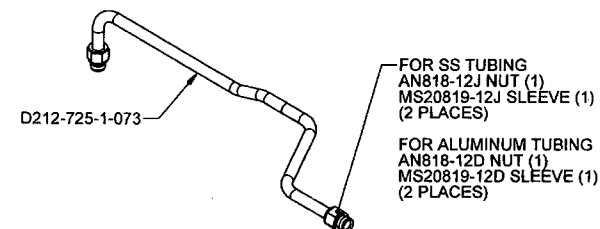
- 1) MATERIAL: AISI 304/316 SS  $\phi 0.750 \times 0.049$  WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.750W.049) OR 6061-T6 OR 6061-T62 ALUMINUM TUBING  $\phi 0.750 \times 0.035$  WALL (REF. DART SPEC. M6061T6TR0.750W0.035)
- 2) FINISH: FOR ALUMINUM TUBING ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY (-913/-915) WITH DART P/N USING FINE POINT PERMANENT INK MARKER



SECTION K-K  
(FINISH FLARE ONE END  
AFTER ASSEMBLY)  
SCALE 1:2



**D212-725-1-913 DRAIN TUBE ASSY**



**D212-725-1-915 DRAIN TUBE ASSY**

**RELEASED**  
08-07-11

B	07.05.11	ADD NOTE FABRICATE FROM SS	
A	06.12.08	NEW ISSUE	
DESIGN	DC	DRAWN BY	RF
CHECKED	DS	APPROVED	<i>[Signature]</i>
DATE	07.05.11	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
		DRAWING NO. D212-725-1	SHEET 28 OF 44
		TITLE 212S DETAIL PARTS	SCALE 1:8
COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONVICTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries